

Date: Friday, 12/09/2008 11:19:56 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ROD
Job Number :	41922		
Estimate Number :	10742		
P.O. Number :		Part Number :	D31343
This Issue :	12/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3134 REV D
First Issue :	09/09/2008	Project Number :	N/A
Previous Run :	24682	Drawing Revision :	D
		Material :	
		Due Date :	12/09/2008
Written By :		Qty:	8 Um: Each
Checked & Approved By :			
Comment :	Est. B 02.11.12 Re-format; Add thread KJ		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TR0250W049

304 Seamless Tubing .250 x .049w

**Comment:** Qty.: 2.3888 f(s)/Unit Total : 19.1100 f(s)

Cut material to length as per template D3134-3/-4T1

Material: AISI 304/316 Annealed SS tubing 0.250OD x 0.049 wall (M304TR0.250W.049)

Batch: M1092416

08-09-15 (C)

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Open both ends with Ø0.161 (#20) drill and thread both ends as per Dwg D3134

Deburr rod, no sharp edges.

Bend as per Dwg D3134 using template D3134-3T3

08-09-15 (C)

3.0

QC5

INSPECT WORK TO CURRENT STEP

**Comment:** INSPECT WORK TO CURRENT STEP

08-09-15 (6)

4.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

08-09-15 (C)

5.0

QC21

(FINAL INSPECTION/W/O RELEASE)

**Comment:** FINAL INSPECTION/W/O RELEASE

08/09/15

Job Completion



MF 08-09-15

- Two rods measure 26.675" which is .095" out of tolerance
deviation is acceptable

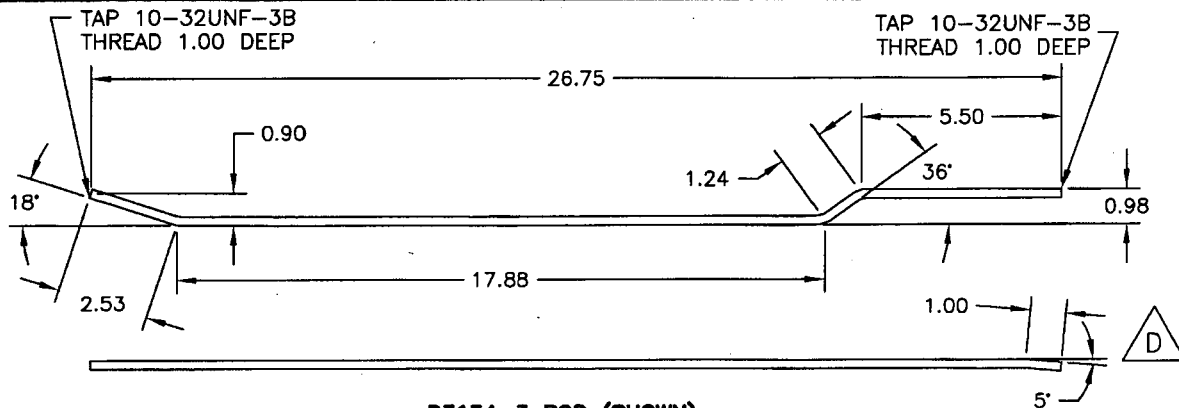
Q5102 #10

- Parts will fit with mating parts : ASS'Y

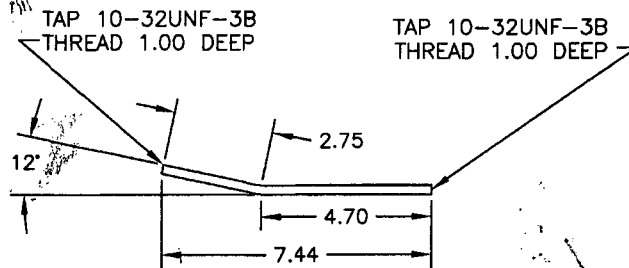
08.09.15 Q5102 #10

109248

0159 no21

DART**D3134-3 ROD (SHOWN)**

(REPLACES PREMIER P/N B30-23000-139)

D3134-4 ROD (OPPOSITE)**D3134-1 ROD**

(REPLACES PREMIER P/N B30-23000-137)

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	<input checked="" type="checkbox"/>	APPROVED	<input checked="" type="checkbox"/>	HAMKESBURY, ONTARIO, CANADA
DATE	06.05.08	DRAWING NO.	D3134	REV. E
		TITLE	ROD	SHEET 1 OF 2
				SCALE
				NTS
A	02.04.17	NEW ISSUE		
B	02.09.26	ADD "ANNEALED" SPEC; REDESIGNED D3134-1		
C	04.10.18	ADD PART MARKING		
D	05.12.05	CORRECT VIEW		
E	06.05.08	ADD -5, REF DSI 9331		

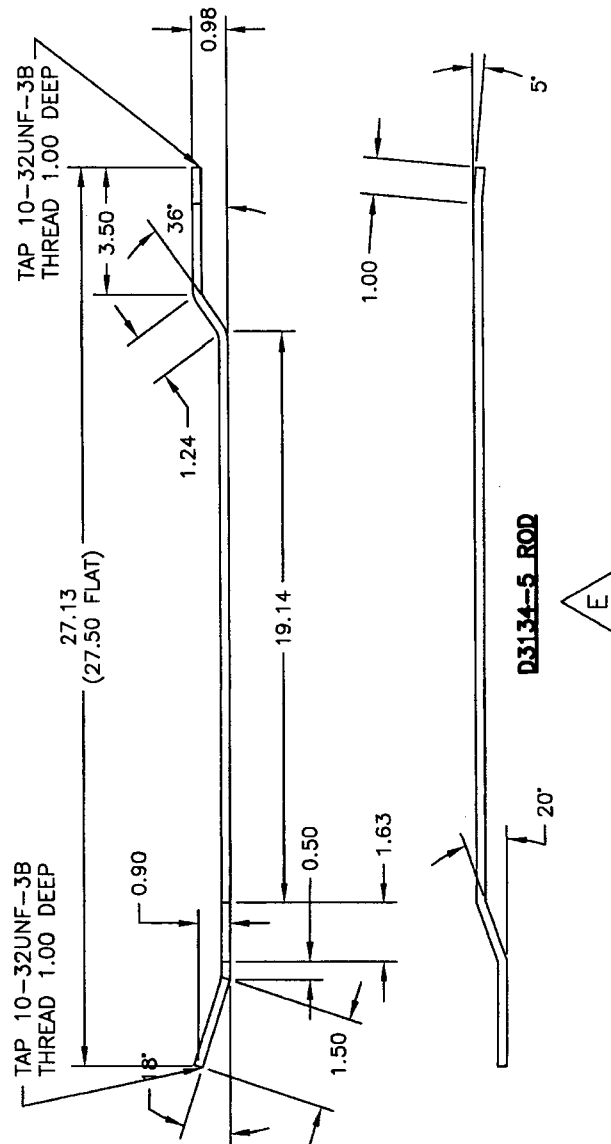
NOTES

- 1) MATERIAL: AISI 304/316 ANNEALED SS TUBING 0.250 OD x 0.049 WALL
(REF DART SPEC. M304TR0.250W.049)
- 2) TOOLING: MAKE D3134-1 PER TOOL DT8656
MAKE D3134-3 PER TOOL DT8657
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

W/O 41922

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3134	REV. E SHEET 2 OF 2
DATE 06.05.08	TITLE ROD	SCALE NTS	



22614

RELEASED
06.05.09